# Work Order ID 100574

*Tuesday, April 23, 2013 1:29:14 PM*

*100574*



**Item ID:** D350-588-011 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Start Qty:** 10.00 *10*

**Required Date:** 5/24/2013 **Req'd Qty:** 10.00 *10*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** 13-04-23 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| N/A | Rev N/A | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | **Memo** | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile and create labels per PPP D350-588-011 CHG002 | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS 06 9-88 13/6/10 10 for MCS 13-6-7 (10)

ML. 10X 13/05/24 SP

DAS 06 9-88 13/6/10 10

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Work Order ID 100574

*Tuesday, April 23, 2013 1:29:14 PM*

*100574*

**Item ID:** D350-588-011 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Start Qty:** 10.00 *10*

**Required Date:** 5/24/2013 **Req'd Qty:** 10.00 *10*

**Reference:**

**Cust Item ID:**

**Customer:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | | 0.00 | | | | | | | |
| *130* | Packaging | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D350-588-011<br>Location: 02<br>PPP Rev: _____ | | | | | 10 | DAS 06 9-8 | B16/10 | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | 13/6/11 | |

CMF 13-6-10

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*Tuesday, April 23, 2013 1:29:18 PM*



**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

**Comments:** IPP Rev:M04.08.31Added D2690-17KJ/JLM

| Component Item ID / Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| AN526C1032R7 *AN526C1032R7* Screw | | Purchased | No | | | 120 | Each | 74.0000 | 2 ** | 20 | | | |
| | | | | Location | | Loc Qty | Loc Code | | | | | | |
| | | | | ST346 | | 74 | | | | | | | |
| | | | | | 123831 | 74 | | | | | | | |
| AN526C832R8 *AN526C832R8* Screw | | Purchased | No | | | 120 | Each | 140.0000 | 8 ** | 80 | | | |
| | | | | Location | | Loc Qty | Loc Code | | | | | | |
| | | | | ST345 | | 140 | | | | | | | |
| | | | | | 122814 | 8 | | | | | | | |
| | | | | | 123522 | 32 | | | | | | | |
| | | | | | 124552 | 100 | | | | | | | |
| AN526C832R9 *AN526C832R9* Screw | | Purchased | No | | | 120 | Each | 95.0000 | 8 ** | 80 | | | |
| | | | | Location | | Loc Qty | Loc Code | | | | | | |
| | | | | ST345 | | 95 | | | | | | | |
| | | | | | 124552 | 95 | | | | | | | |
| AN960JD10 *AN960JD10* Washer | NAS1149D0363J | Purchased | No | | | 120 | Each | 0.0000 | 4 ** | 40 | | | |
| AN960JD8 *AN960JD8* Washer | NAS1149DN832 | Purchased | No | | | 120 | Each | 0.0000 | 24 ** | 240 | | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

# Picklist Print

*Tuesday, April 23, 2013 1:29:18 PM*

**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

| | | | | | | |
|---|---|---|---|---|---|---|
| D2143 *D2143* Hinge Bracket | Manufactured | No | 120 | Each | 18.0000 | ** |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST005 | 18 | |
| 92166 | 18 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| D2144 *D2144* Hinge Bracket | Manufactured | No | 120 | Each | 23.0000 | ** |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST005 | 23 | |
| 92181 | 23 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| D2150 *D2150* Packer Doubler, Hinge | Manufactured | No | 120 | Each | 14.0000 | ** |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST005 | 14 | |
| 92182 | 14 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| D2151 *D2151* Packer Doubler, Hinge | Manufactured | No | 120 | Each | 48.0000 | ** |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST005 | 48 | |
| 92172 | 18 | |
| 95852 | 30 | |

13/05/27

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
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- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*Tuesday, April 23, 2013 1:29:18 PM*

**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

| | | | | | | |
|---|---|---|---|---|---|---|
| D2153 | Manufactured | No | 120 | Each | 41.0000 | ** |

*D2153*
Door Prop

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 5 | |
| 85865 | 5 | |
| ST260 | 36 | |
| 95843 | 1 | |
| 97385 | 35 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| D2154 | Manufactured | No | 120 | Each | 26.0000 | ** |

*D2154*
Stud Bracket

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST006 | 26 | |
| 82333 | 26 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| D2237 | Manufactured | No | 120 | Each | 11.0000 | ** |

*D2237*
Striker Plate

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST007 | 11 | |
| 91815 | 1 | |
| 93697 | 10 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*Tuesday, April 23, 2013 1:29:18 PM*

**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

D2461 Manufactured No 120 f 361.4939 7.25 76.31579 **

*D2461*

Neoprene "D" Seal

10X 87"

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST415 | 361.493894 | |
| 39782 | 6.5 | |
| 55054 | 4 | |
| 63880 | 14.8237 | |
| 73644 | 113.702984 | |
| 85225 | 222.46721 | |

cut 1 X 87.00"

D2463 Manufactured No 120 f 1,046.880 7.25 76.31579 **

*D2463*

Seal

18X 87"

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST403 | 1046.88028 | |
| 72232 | 15.38 | |
| 79478 | 0.43737 | |
| 83542 | 0.04291 | |
| 90297 | 52.77 | |
| 95774 | 478.25 | |
| 98335 | 500 | |

cut 1 X 87.00"

D2583 Manufactured No 120 Each 36.0000 2 20 **

*D2583*

Latch Bracket

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST012 | 36 | |
| 92189 | 2 | |
| 95906 | 24 | |
| 97249 | 1 | |
| 97585 | 9 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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# Picklist Print

*Tuesday, April 23, 2013 1:29:19 PM*

**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

| | | | | | | |
|---|---|---|---|---|---|---|
| D2585 | Manufactured | No | 120 | Each | 52.0000 | ** |

*D2585*

Mounting Channel

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST012 | 52 | |
| 73297 | 3 | |
| 91960 | 1 | |
| 95951 | 16 | |
| 97294 | 20 | |
| 97608 | 12 | |

8x 95951 M.D.

12x B97608

| | | | | | | |
|---|---|---|---|---|---|---|
| D2586 | Manufactured | No | 120 | Each | 92.0000 | ** |

*D2586*

Door Latch

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 12 | |
| 83893 | 10 | |
| 95760 | 2 | |
| return2013 | 3 | |
| xxxxx | 3 | |
| ST198A | 77 | |
| 95760 | 77 | |

B 95760 M.D.

| | | | | | | |
|---|---|---|---|---|---|---|
| D2587 | Manufactured | No | 120 | Each | 2.0000 | ** |

*D2587*

Door Slug, 350 Hinge

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST012 | 2 | |
| 92171 | 2 | |

B 95850 M.D.

13/05/24

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

## FAULT CATEGORY

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*Tuesday, April 23, 2013 1:29:19 PM*

**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

| | | | | | | |
|---|---|---|---|---|---|---|
| D2589 | Manufactured | No | 120 | Each | 101.0000 | ** |

*D2589*

Keys, Key Chain, 350 Hinge

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST012 | 101 | |
| 58194 | 101 | |

B58194 M.D.

| | | | | | | |
|---|---|---|---|---|---|---|
| D2690-17 | Manufactured | No | 120 | Each | 28.0000 | ** |

*D2690-17*

Cable

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST016 | 28 | |
| 85866 | 3 | |
| 91824 | 4 | |
| 92128 | 9 | |
| 94470 | 4 | |
| 95699 | 8 | |

3X B85866 M.D.

7X B92128 M.D.

| | | | | | | |
|---|---|---|---|---|---|---|
| D2857-1 | Manufactured | No | 120 | Each | 31.0000 | ** |

*D2857-1*

Hinge Bracket

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 5 | |
| 82261 | 4 | |
| 91914 | 1 | |
| ST019 | 26 | |
| 91914 | 14 | |
| 95859 | 12 | |

2X B91914 M.D.

8X B95859

13/05/24

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

**Work Order ID:** 100574 *100574*
**Parent Item:** D350-588-011 *D350-588-011*
**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013
**Start Qty:** 10.00 **Required Qty:** 10.00

| | | | | | | |
|---|---|---|---|---|---|---|
| D2857-2 | Manufactured | No | 120 | Each | 37.0000 | ** |

*D2857-2*
Hinge Bracket

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 4 | |
| 78904 | 4 | |
| ST019 | 13 | |
| 95712 | 13 | |
| ST020 | 20 | |
| 85806 | 1 | |
| 92134 | 19 | |

B92134

| | | | | | | |
|---|---|---|---|---|---|---|
| D2858-1 | Manufactured | No | 120 | Each | 39.0000 | ** |

*D2858-1*
Hinge Bracket

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 2 | |
| 77019 | 2 | |
| ST019 | 37 | |
| 82337 | 1 | |
| 91826 | 15 | |
| 95701 | 21 | |

B91826

| | | | | | | |
|---|---|---|---|---|---|---|
| D2858-2 | Manufactured | No | 120 | Each | 42.0000 | ** |

*D2858-2*
Hinge Bracket

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 2 | |
| 77020 | 2 | |
| ST020 | 40 | |
| 89263 | 19 | |
| 95851 | 21 | |

B89263

13/05/24

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

## FAULT CATEGORY

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*Tuesday, April 23, 2013 1:29:19 PM*

**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

FG-778150-550-ROL Purchased No 120 sf 1,209.160 10 **

*FG-778150-550-ROL*

7781 9oz Glass 50"x125yd

| Location | Loc Qty | Loc Code |
|---|---|---|
| CA | 1209.16 | |
| 123239 | 1209.16 | 123239 M.D. |

1- cut 1 squarre ft of glass cloth

MS20426AD3-4 Purchased No 120 Each 22,331.00 120 **

*MS20426AD3-4*

RIVET

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST333 | 331 | |
| 123021 | 235 | |
| 123352 | 96 | |
| ST334 | 8000 | |
| 123164 | 8000 | |
| ST505 | 8000 | |
| 124814 | 8000 | |
| ST509 | 6000 | |
| 124586 | 6000 | 124586 M.D. |

MS20470AD4-5 Purchased No 120 Each 1,271.000 180 **

*MS20470AD4-5*

Rivet, Universal Head

| Location | Loc Qty | Loc Code |
|---|---|---|
| GA | 438 | |
| 122452 | 438 | |
| ST336 | 833 | |
| 122452 | 833 | 122452 M.D. 13/05/24 |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

**Work Order ID:** 100574 *100574*

**Parent Item:** D350-588-011 *D350-588-011*

**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013

**Start Qty:** 10.00 **Required Qty:** 10.00

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| MS21042L08 *MS21042L08* Nut | Purchased | No | | 120 | Each | 3,021.000 ** | 18 / 80 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST315 | 3021 | |
| 122141 | 3 | |
| 122452 | 9 | |
| 122814 | 500 | |
| 123900 | 2509 | |

123900 MD.

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| MS21042L3 *MS21042L3* Nut 50 | Purchased | No | | 120 | Each | 4,646.000 ** | 4 / 40 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP001 | 3 | |
| 122141 | 3 | |
| GA | 92 | |
| 122452 | 92 | |
| ST314 | 268 | |
| 117885 | 32 | |
| 119017 | 55 | |
| 119075 | 138 | |
| 123265 | 43 | |
| ST506 | 4283 | |
| 123900 | 974 | |
| 124291 | 3309 | |

124291 MD. 13/05/24

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

**Work Order ID:** 100574 *100574*
**Parent Item:** D350-588-011 *D350-588-011*
**Parent Item Name:** Aft Door Fwd Hinge Modification

**Start Date:** 4/23/2013 **Required Date:** 5/24/2013
**Start Qty:** 10.00 **Required Qty:** 10.00

| | | | | | | |
|---|---|---|---|---|---|---|
| MS27039-08-11 | Purchased | No | 120 | Each | 660.0000 | ** |

*MS27039-08-11*
Screw

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST307 | 660 | |
| 122441 | 100 | |
| 123352 | 500 | |
| 123900 | 60 | |

125654 M.D.

| | | | | | | |
|---|---|---|---|---|---|---|
| MS27039-1-15 | Purchased | No | 120 | Each | 955.0000 | ** |

*MS27039-1-15*
Screw

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST506 | 955 | |
| 124326 | 955 | |

124326 M.D.

13/05/23

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- . ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

## FAULT CATEGORY

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

REFERENCE ONLY

## 3.3 WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|---|---|---|---|---|---|
| | | Arm | Moment | Arm | Moment |
| D350-588-011<br>Aft Door Fwd Hinge Modification Kit | 1.0 lb<br>0.45 Kg | -21.0 in<br>-0.53 m | -21.0 in-lb<br>-0.24 m-Kg | +170.0 in<br>+4.32 m | +170.0 in-lb<br>+1.96 m-Kg |
| D350-588-041*<br>Aft Door Assembly | 2.0 lb<br>0.91 Kg | -21.0 in<br>-0.53 m | -42.0 in-lb<br>-0.48 m-Kg | +170.0 in<br>+4.32 m | +340.0 in-lb<br>+3.93 m-Kg |

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 3.4 PARTS LISTS

| 588 -041 | 588 -011 | Part Number | Description |
|---|---|---|---|
| X | | D350-588-041 | AFT DOOR ASSEMBLY |
| | X | D350-588-011 | AFT DOOR FWD HINGE MODIFICATION KIT |
| | | | |
| 1 | 1 | D2143 | HINGE DOUBLER |
| 1 | 1 | D2144 | HINGE DOUBLER |
| 2 | 2 | D2150 | HINGE PACKER |
| 2 | 2 | D2151 | HINGE DOUBLER |
| 1 | 1 | D2153-3315-10 | GAS SPRING ASSY. |
| 1 | 1 | D2154 | STUD BRACKET |
| 2 | 2 | D2237 | STRIKER PLATE |
| 1 | | D2445 | DOOR |
| 1 | 1 | D2461-0870 | NEOPRENE D SEAL |
| 1 | 1 | D2463-0870 | ½" FOAM SEAL |
| | 2 | D2583 | LATCH BRACKET |
| 2 | 2 | D2585 | LATCH CLAMP |
| 2 | 2 | D2586 | LATCH |
| | 1 | D2587 | PLUG |
| 1 | 1 | D2589 | KEYS, KEY CHAIN |
| 2 | | D2621 | LATCH PLATE |
| 1 | 1 | D2690-17 | CABLE, DOOR STOP |
| 1 | 1 | D2857-1 | LOWER HINGE BRACKET |
| 1 | 1 | D2857-2 | UPPER HINGE BRACKET |
| 1 | 1 | D2858-1 | LOWER HINGE BRACKET |
| 1 | 1 | D2858-2 | UPPER HINGE BRACKET |
| 8 | 8 | AN526C832R8 | SCREW (or AN526-832R8) |
| 8 | 8 | AN526C832R9 | SCREW (or AN526-832R9) |
| 2 | 2 | AN526C1032R7 | SCREW (or AN526-1032R7) |
| 24 | 24 | AN960JD8 | WASHER |
| 4 | 4 | AN960JD10 | WASHER |
| 12 | 12 | MS20426AD3-4 | RIVET |
| 18 | 18 | MS20470AD4-5 | RIVET |
| 18 | 18 | MS21042L08 | NUT (or MS21042-08) |
| 4 | 4 | MS21042L3 | NUT (or MS21042-3) |
| 2 | 2 | MS27039-1-15 | SCREW |
| 2 | 2 | MS27039-0811 | SCREW |
| 1 | 1 | N/A | 1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS) |

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# DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS D350-588 REV. D, D350-589 REV. E, IIN-D350-600 REV. E, AND IIN-D130-780 REV. B AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-588 REV. 0, ICA-D350-589 REV. 1, ICA-D350-600 REV. 5, AND ICA-D130-780 REV. 1**

REF CANADIAN STC: SH92-41, SH93-88
REF FAA STC: SH1012NE, SR00098NY, SR00099NY
AUSTRIAN STC: ACG.21NE2.093
REF EASA STC: EASA.IM.R.S.01292

## PURPOSE:

The purpose of this DSI (Dart Service Instruction) is to introduce DSI 9585-011 and DSI 9585-013 Latch Repair Kits for D2586 Latches whose springs have failed or have been lost in service. Replacement procedures are as follows:

## PROCEDURE:

**TORSION SPRING REPLACEMENT (DSI 9585-011 KIT):**

1) Remove D2586 Latch by unfastening the MS27039-1-XX Screw and associated hardware. Retain all hardware/parts.
2) Remove and discard roll pin with adequate tool. Discard existing failed spring.
3) Install D4518-1 Torsion Spring by inserting provided MS39086-133 Coiled Spring Pin in place using adequate tool. Refer to Figure 1 of this service instruction.
4) Reinstall repaired D2586 Latch in accordance with respective STC using the hardware/parts removed at Step 1 above.

**LOCK BARREL SPRING REPLACEMENT (DSI 9585-013 KIT):**

1) Remove D2586 Latch by unfastening the MS27039-1-XX Screw and associated hardware. Retain all hardware/parts.
2) Remove and discard roll pin with adequate tool. Discard existing failed spring.
3) Install D4518-3 Lock Barrel Spring by inserting provided MS39086-133 Coiled Spring Pin in place using adequate tool. Refer to Figure 2 of this service instruction.
4) Reinstall repaired D2586 Latch in accordance with respective STC using the hardware/parts removed at Step 1 above.

## PARTS LIST

| QTY -011 | QTY -013 | PART NUMBER | DESCRIPTION |
|---|---|---|---|
| X | | **DSI 9585-011** | **TORSION SPRING REPLACEMENT KIT** |
| | X | **DSI 9585-013** | **LOCK BARREL SPRING REPLACEMENT KIT** |
| | | | |
| 1 | | D4518-1 | TORSION SPRING |
| | 1 | D4518-3 | LOCK BARREL SPRING |
| 1 | 1 | MS39086-133 | COILED SPRING PIN |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: _____
D. SHEPHERD (DE # 02)

DATE:
CERT. NO.: SH92-41/SH93-88
ISSUE NO.: 8/6

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| A | NEW ISSUE (REF. PAR11-135) | MB | 11.12.05 |

| | | |
|---|---|---|
| DESIGN | | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | | |
| CHECKED | | DRAWING NO. DSI 9585 REV. A SHEET 1 OF 2 |
| MFG. APPR. | N/A | |
| APPROVED | | TITLE LATCH REPAIR KIT SCALE NTS |
| DE APPR. | | |
| DATE | 11.12.05 | |

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